








Work Order ID 59614

Tuesday, June 08, 2010 3:36:22 PM


Page 1


Item ID: D4017-5	Accept		Setup	Start	
Revision ID:					
Item Name: Hinge Rib				Stop	
Start Date: 6/8/2010	Start Qty: 1.00		Cust Item ID:		
Required Date: 6/10/2010	Req'd Qty: 1.00		Customer:		
Reference:					


Approvals:	Process Plan: <u>nr</u>	Date: <u>10-6-8</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool # . Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4017	B

100		0.00						
								
Large Fab	Memo	0.00						
Large Fab	1- Cut tube as per dwg D4017 2- Deburr and remove identify marks		SAD	10-06-09				

110	QC5- Inspect part completeness to step on W/O	0.00						
								
QC	Memo	0.00						
Quality Control								

120	Identify as per dwg & Stock Location: <u>WA</u>	0.00						
								
Packaging	Memo	0.00						
Packaging			SAD	10-06-09				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4017-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Rib

Start Date: 6/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09 *[Signature]*
MF
10-6-9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 59614



Parent Item: D4017-5



Parent Item Name: Hinge Rib

Start Date: 6/8/2010

Required Date: 6/10/2010

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC
per dwg RevA DD 10.03.06 verified by:EC
DD 10.04.16 verified by:EC

IPP Rev:B as

IPP Rev:C as per dwg RevB

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304TS0.750W.049		Purchased	No			100	f	366.8280	4.604	4.846316			



304 SQ Tube .75x.75x.049W



SAD 10-06-09

Location

Loc Qty

Loc Code

MAT

366.8279789

113763

0

114323

29.5677289

114677

37.26025

114835

300

MAT017

3.68448E-05

114298

3.6845E-05

4.846316

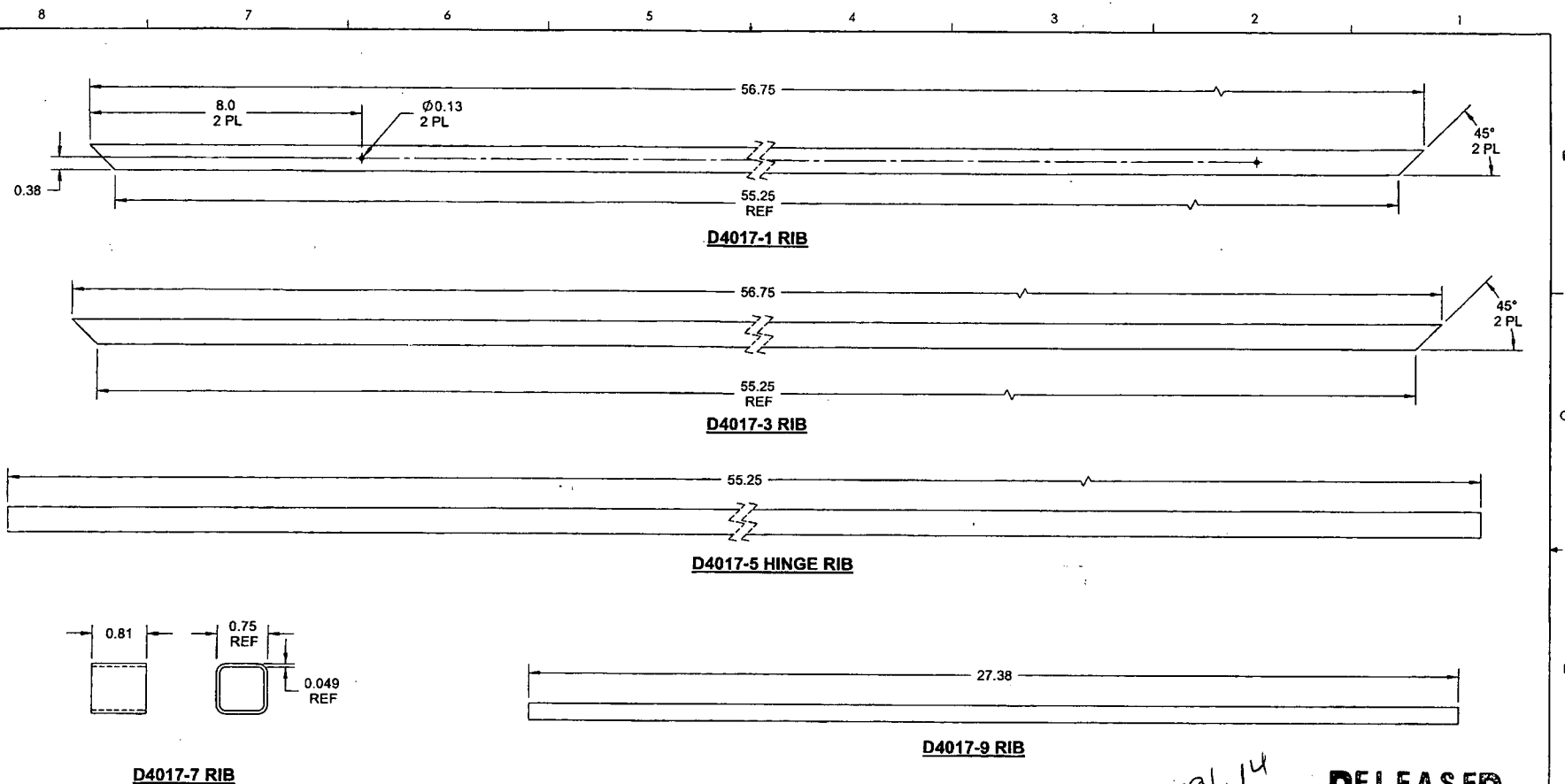
W/O:		WORK ORDER CHANGES					
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NOTES:

1) MATERIAL -1 THRU -7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-8: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-31

#59614

W/O:		WORK ORDER CHANGES					
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